

Work Order ID 86358

86358

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June-27-12 3:45:29 PM

Item ID: D2175-2

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Angle RH

Start Date: 27/06/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/28 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2175	Rev E								
100		0.00							
100	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2175								
2024.063	Dwg Rev: <u>E</u>								
	Prog Rev: <u>E</u>								
	2-Deburr if necessary								
110		0.00							
110	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

4 0 Jun 12-7-7

4 0 Jun 12-7-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

130

Small Fab

Small Fab

0.00

Memo

0.00

Small Fab

Deburr Stack

140

140

Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

Form as per Dwg D2175

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N900040100

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Stop *NS2*

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Start Date: 27/06/2012 **Start Qty:** 4.00

4

Customer:

Required Date: 11/07/2012 **Req'd Qty:** 4.00

4

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

**Insp.
Stamp**

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

170

QC7-Inspect Chemical Conversion Coat

0.00

170

QC

Memo

0.00

Quality Control

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: _____	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

PC 12/7/12 (4)

MLS 12/07/12

MLS 12/07/12

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Picklist Print

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Page 1

Work Order ID: 86358

86358

Parent Item: D2175-2

D2175-2

Parent Item Name: Angle RH

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP E04.06.09ReformatKJ/RF

IPP Rev:F 06-04-28 Manufactured on Water Jet JLM

IPP Rev:G As per Rev E 06-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.063

Purchased

No

100

sf

245.3900

0.4722

1.988211

M2024T3S 063

**

2024-T3 .063 sheet

Jm 12-7-7

Location

Loc Qty

Loc Code

MAT022

245.39

119916

72.85

121197

172.54

119916

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DART AEROSPACE LTD		Work Order:	86358
Description: Angle		Part Number:	D2175-1/-2
Inspection Dwg: D2175 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.650	+/-0.010	12.650	✓		MT	H301
R0.35	+/-0.030	0.35"	✓		RG	
2.915	+/-0.010	2.915"	✓		✓	mm01
50°	+/-0.5°	50°	✓		Protractor	
0.300	+/-0.010	0.303"	✓		✓	mm01
1.050 Pitch	+/-0.010	1.051"	✓		✓	"
10.500	+/-0.010	10.502"	✓		✓	Protractor
11.550	+/-0.010	11.553"	✓		✓	"
0.550	+/-0.010	0.551"	✓		✓	mm01
0.900	+/-0.010	0.906"	✓		✓	"
0.063 thick	+/-0.010	0.063"	✓		✓	mm01
Grain Direction	N/A		✓			mm01
Ø0.128	+0.005/-0.001	0.129"	✓		✓	mm01
Ø0.172	+0.005/-0.001	0.174"	✓		✓	"

Measured by: JM	Audited by: S	Prototype Approval:	N/A
Date: 12-7-7	Date: 12/6/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.03.23	Dimensions revised per Dwg rev. E	KJ/JLM	

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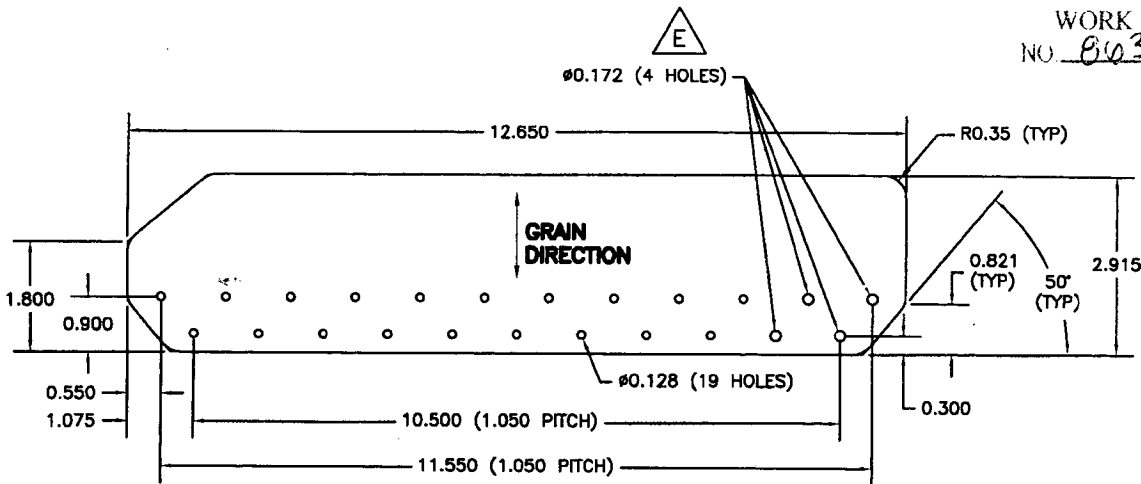
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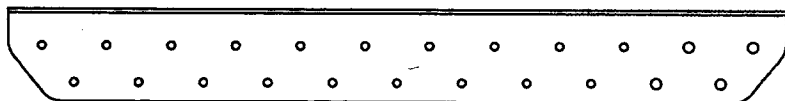
DART

RELEASED
12/06/28

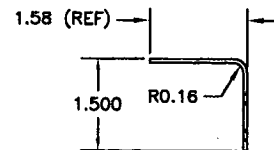
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 80358 MLJ



D2175-1F FLAT PATTERN



**D2175-1 BEND DETAIL SHOWN
(D2175-2 BENT OPPOSITE)**



DESIGN	RF	DRAWN BY	DATE	CHECKED	APPROVED	DRAWING NO.	TITLE	SCALE
			06.09.25	PH		D2175	ANGLE	1:3
A		95.10.25	NEW ISSUE					
B		96.01.18	CHANGED DIMENSION					
C		00.09.11	UPDATE FINISH SPEC					
D		04.06.03	RE-DESIGN					
E		06.09.25	INC HOLE DIA TO 0.172, 4 HOLES					

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES

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